

Date: Friday, 25/07/2008 4:20:50 PM
 User: Julie Lecocq

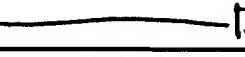
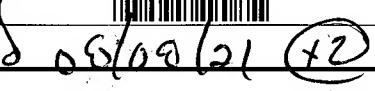
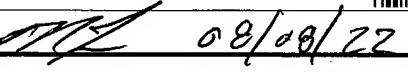
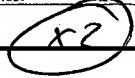
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET		
Job Number	: 40762			Part Number	: D21953		
Estimate Number	: 13508			Drawing Number	: D2195 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/07/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/08/2008		
Previous Run	:			Qty:	2	Um:	Each
Written By	:						
Checked & Approved By	: <u>Jul 08.7.25</u>						
Comment	: Est Rev:A 08-07-24 new issue ec verified by:dd						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
Comment: Qty.: 0.3686 f(s)/Unit Total : 0.7371 f(s) 6061t6 bar 5.00" x .50" thick batch: <u>106747</u> <u>HB 8-8-21</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2195 Dwg Rev: <u>C</u> <u>HB 8-8-21</u>  Prog Rev: <u>C</u>		
2-Deburr if necessary <u>HB 8-8-21</u>   <u>Hm08/08/21</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1  		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:51 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40762

Part Number: D21953

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08.22

(X2)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(21)

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: 18

818125

SJ

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/2010

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

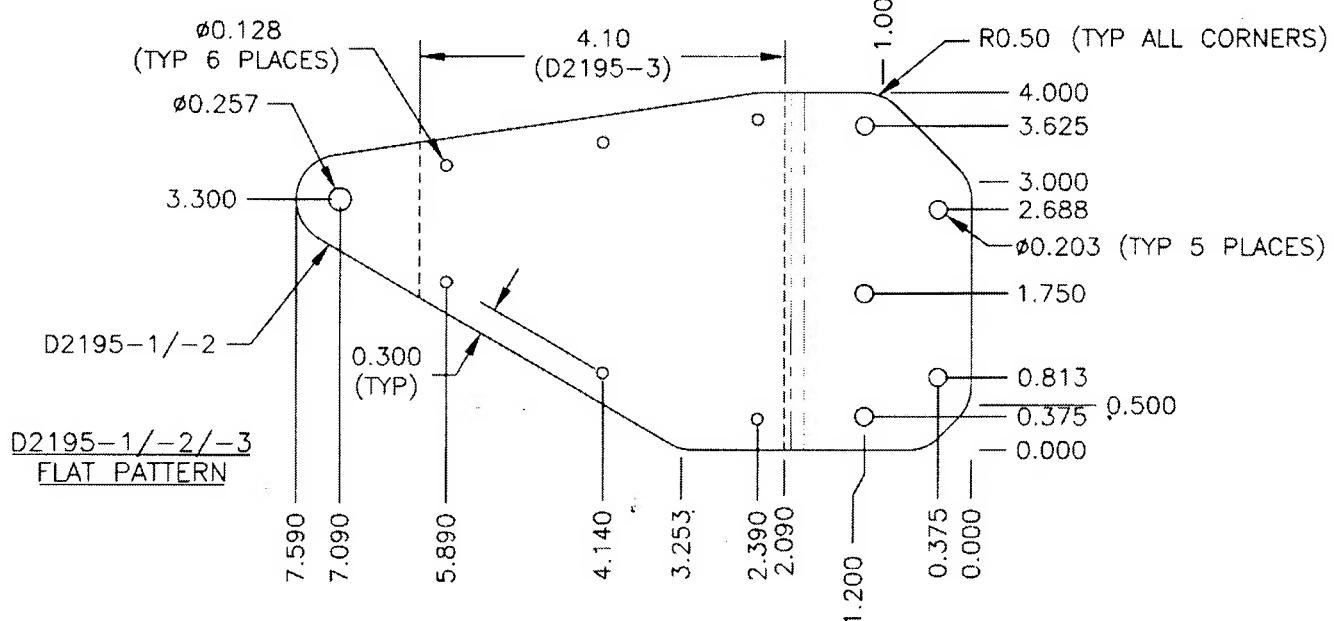
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2195	SHEET 1 OF 1
DATE		TITLE	SCALE
03.05.28		BRACKET	1:2
B	93.09.23	RE-DESIGN	
C	03.05.28	REDRAW; D2195-3 NOW 0.5" THICK	

07.07.09 AF



D2195-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.06" THICK (M304S16GA)

D2195-3

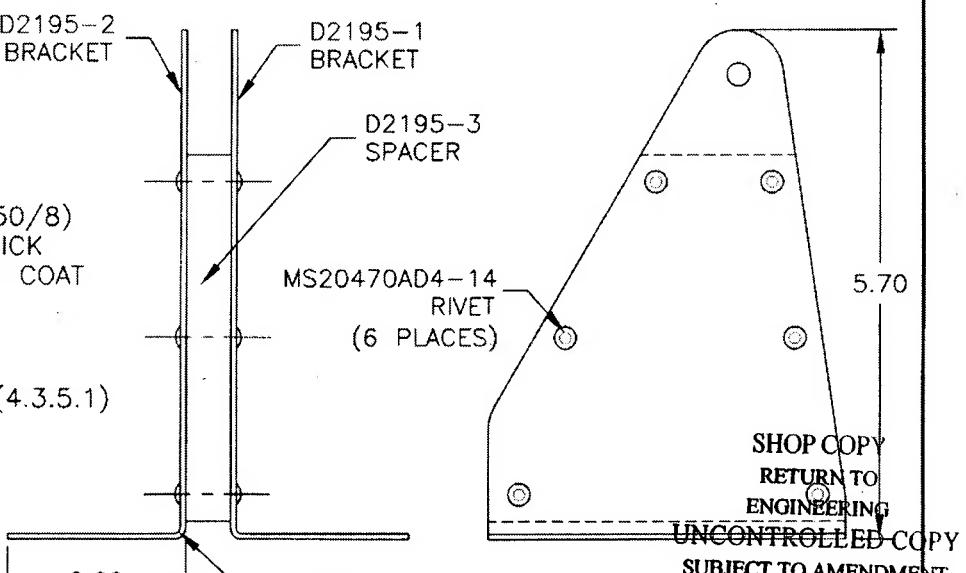
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2195 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN
INCHES
- 6) TOLERANCES ARE PER
DART QSI 018 UNLESS
OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2195 BRACKET
(ASSEMBLY)

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DART AEROSPACE LTD	Work Order:	40762
Description: BRACKET	Part Number:	D2195-3
Inspection Dwg: D2195-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>DS</u>	Prototype Approval: <u>✓</u>
Date: <u>8-8-21</u>	Date: <u>08/08/21</u>	Date: <u>✓</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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